

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014334**Date Inspected:** 21-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY # 14

ULTRASONIC INSPECTION**OBG SEGMENT 12BE**

ABF Report No: UT-12E-005

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Bike path side) of OBG segment 12BE. The weld designations are as follows.

CA3003-004 (12BE-D.P to E.P, Bike path side)

ULTRASONIC INSPECTION**OBG SEGMENT 12BE**

WELDING INSPECTION REPORT

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ABF Report No: UT-12E-006

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between deck panel and edge panel (Cross beam side) of OBG segment 12BE. The weld designations are as follows.

CA3002-004 (12BE-D.P to E.P, Cross beam side)

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7DW-7CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067665 performing Shielded Metal Arc Welding process for weld OBW7N-010 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4b-Fcm-1.

OBG SEGMENT 7BW-7CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048696 performing Flux Cored Arc Welding process for weld SP130-001-29 located on PCMK. Hold back weld between "T" rib and side panel near splice weld between OBG segment 7BW and 7CW. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG SEGMENT 7DW-7EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045196 performing Shielded Metal Arc Welding process for weld OBW7A-008 located on PCMK. Deck panel splice weld between OBG segment 7DW and 7EW. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) FCM-Repair-1.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
